

Work Order ID 160448***160448***

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Thursday, April 27, 2017 3:16:48 PM

Item ID: D4004-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Top Strap Attachment Bracket
Start Date: 5/15/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 5/17/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: APR 28 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4004	B								
100		0.00							DAS 32 9-89
100	BAND SAW					3	Ø		
Bandsaw	Memo	0.80							
Jeaspa Bandsaw	1-Cut D3033-144 extrusion to length per D4004-11 detail of dwg D4004								17-05-03
	Ensure cut is started at correct place per dwg								
	Batch: <u>151903</u>								
	2-Deburr								
105		0.00							DAS 19 9-89
105						3	Ø		
Small Fab	Memo	0.69							MAY 03 2017
Small Fab	Drill and c'sink holes as per dwg and trim part to length as required.								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	Past Due ☐							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.06				<u>3</u>			DAS 38 9-89 MAY 03 2017
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.61				<u>(x3)</u>	<u>6</u>		20170510? BEB
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.03				<u>3</u>			DAS 38 9-89 MAY 09 2017

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Customer:

Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>Sto 70</u>	0.00							
140									
Packaging	Memo	0.03							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.30							
Quality Control									

3 MAY 09 201717/5/11 28DAS
21
3-89

MAY 10 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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		OTHER : _____							

Picklist Print

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Work Order ID: 160448

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Parent Item: D4004-11

D4004-11

Parent Item Name: Top Strap Attachment Bracket

Start Date: 5/15/2017

Required Date: 5/17/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf:EC IPP Rev:C 12.03.07
as per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3033-144		Manufactured	No			100	f	381.7200	0.41	1.294737			DAS
D3033-144									**			17-05-03	32 9-89

Seat Track (\$ per foot)

Location	Loc Qty	Loc Code
ST479a	381.72	
131913	381.72	

1.844'

DQA: _____ Date: _____



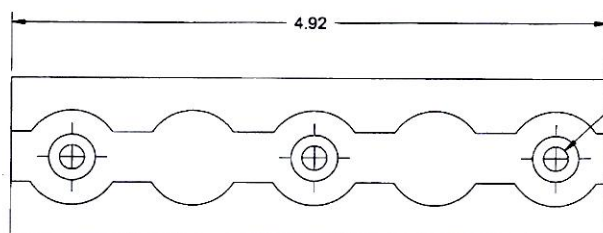
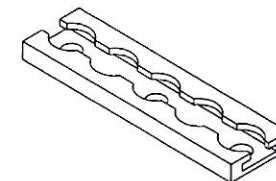
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

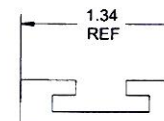
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-11	JCA-M47-2-11



DRILL $\varnothing 0.204$ (#6 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\varnothing 0.385 \times 100^\circ$
3 PL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160448 M15
170428

D4004-11 TOP STRAP ATTACH BRACKET

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLIN P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.14 lbs

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BC</i>	D4004	SHEET 11 OF 11
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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